

Date: Monday, 12/03/2007 11:13:15 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPAD	
Job Number	: 31165		Part Number	: D35377	
Estimate Number	: 12801		Drawing Number	: D3537 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 12/03/2007	S.O. No. : N/A	Drawing Revision	: A	
Prshrt Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 19/03/2007	
Previous Run	: N/A		Qty:	1	Um: Each
Written By	: <u>EC</u>				
Checked & Approved By	: _____				
Comment	: Est Rev:A New Issue 07-03-12 ec				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet 
Comment: Qty.: 0.1512 sf(s)/Unit Total: 0.1512 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>M101463</u> <u>ml 07 03 02</u> ①		
2.0	WATER JET	FLOW WATER JET 
Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: <u>A</u> <u>ml 07 03 12</u> ② Prog Rev: <u>A</u>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>ml 07 03 12</u> ③		
4.0	QC8	SECOND CHECK 
Comment: SECOND CHECK <u>M07/03/13</u> ④		
5.0	BRAKE NC	NC BRAKE 
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. <u>SB 07/03/14</u> ⑤		

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Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



07/03/14



Comment: INSPECT WORK TO CURRENT STEP

Ensure nozzle as per dwg D3429

7.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

M02755

FC 07/03/19 ①

Weld hardcoat as per Dwg D3437

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/19 ①

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/19 ①

10.0 POWDER COATING POWDER COATING



M101601



①

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-l 07/03/19

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/19 ①

12.0 PACKAGING.1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/03/19 ①

13.0 QC21 FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

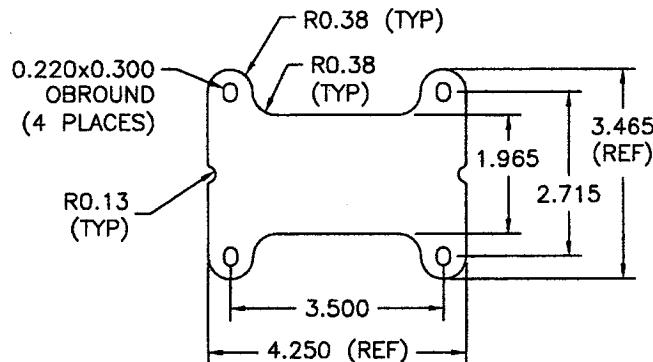
07/03/19

Job Completion

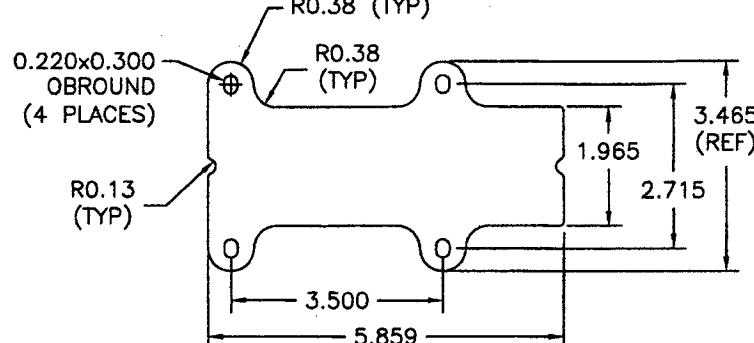


07/03/19

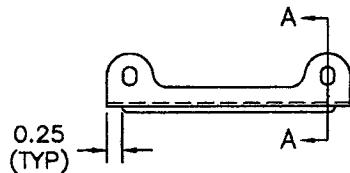
D3537-1F FLAT PATTERN



D3537-3F FLAT PATTERN

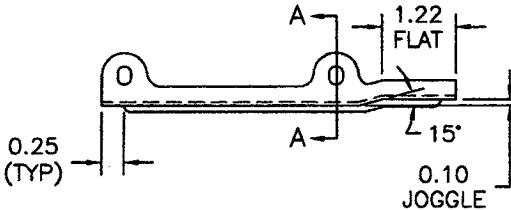


D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)

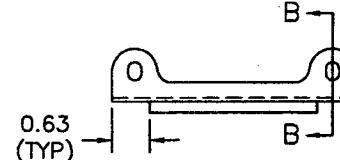


RELEASED
07.02.12

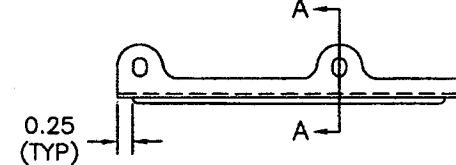
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK, REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART
CB	CB	DART AEROSPACE USA, INC. PORT HUENEMER, WA
CHECKED	APPROVED	DRAWING NO. D3537
PH	H	REV. A SHEET 1 OF 1
DATE		TITLE WEARPAD
06.11.06		SCALE 1:2

DART AEROSPACE LTD	Work Order:	31165
Description: Wear pad	Part Number:	D 3537-7
Inspection Dwg: D 3537 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by: M. M
Date: 07 03 12

Audited by:	<u>AA</u>
Date:	<u>07/03/13</u>

Prototype Approval:	<i>NA</i>
Date:	

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/JLM	

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